

Split

Work Order ID 102091 →

Thursday, May 23, 2013 3:29:44 PM

102091

Page 1

Item ID: D3179-041
Revision ID: ~~JHR~~ N/A J

Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013 Start Qty: 8.00

Required Date: 5/30/2013 **Req'd Qty:** 8.00

References:

Reference:

Approvals: Process Plan: MP

Accept

N900040100

Setup Start

NS1

Stop

NS2

* 8 *

Cust Item ID:

* 8 *

Customer:

Run Start

NP1

Stop

NR2

DQA:

Aut

Date: 13/08/22

QA Closed:

OK

Date: 13/08/21

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: <u>102091</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3179-041</u>	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. <u>13-2962</u>	Scrap <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input checked="" type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design Doc/Data	<u>13/05/31</u>	110	x1	program was supposed to use 1/2" endmill to make pocket instead used 3/4 endmill pocket dims are 250" wider + higher than nominal	<u>QP</u>	Acceptable	<u>QP</u>	<u>13/5/31</u>	<u>DAJ 10/08/21</u>
Equip/Tooling					<u>13/5/31</u>	Not high stress area	<u>13/5/31</u>	<u>13/5/31</u>	
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

Work Order ID 102091

Thursday, May 23, 2013 3:29:44 PM

102091

Page 2

Item ID: D3179-041

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Item Name: Fwd Litter Tie Down

Stop

NS2

Start Date: 5/30/2013 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 5/30/2013 **Req'd Qty:** 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

13-6-3

8

DAS
04
S-83

130

QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

8 NG1385

140

HandFinish

Hand Finishing

150

QC3- Inspect Part Finish

0.00

8X Ø M.F 13/06/05

150

QC

Quality Control

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input checked="" type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

FAULT CATEGORY

Landing Gear	General			
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
Crushing	Countersink	Misaligned/off center	Positioned Wrong	
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	
Inspection Strip in Tube	Drawing	Misread		
Marks/Chatter	Drill Holes	Off-set		
Turning Sequence	Finish	Out of Calibration		
Wave/Twist in Tube	Fit/Function	Out of Sequence		
			<input checked="" type="checkbox"/> Other	origin

Work Order ID 102091

Thursday, May 23, 2013 3:29:44 PM

102091

Page 3

Item ID: D3179-041

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Item Name: Fwd Litter Tie Down

Stop

NS2

Start Date: 5/30/2013 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 5/30/2013 **Req'd Qty:** 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

160

160

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

8x8 mf 13/06/06

Memo

7/10

0.00

START TIME:

3200

OVEN TEMPERATURE:

7/40

170

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

8x4 ll w/loc

Memo

0.00

180

180

Small Fab

Small Fab

0.00

2

Ø

FF 13-08-15

Memo

0.00

Assemble as per Dwg D3179

NOTE: Acceptable to
OPEN UP Ø0.242" HOLES
TO Ø0.248"-0.250"
FOR INSTALLATION OF D2372
PINS.

QSI 042
13.06.06

DQA:

John

Date: 13/08/22

QA Closed:

John

Date: 13/08/21

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order:	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering		
Part No.	Suspected Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality			
NCR No.			Thermoforming	Finishing	Rec/Store/Packaging	Other			
			Large Fab	Composite	Supplier				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design Doc/Data	13-05-31	110	x1	re taking Y origin on 3rd op, tool holder with edge Finder hit part and took .100" gause out of bottom of part R.L. LOA operator was in Pkg Hatch to Jop	DAS 16 052022 3/06/03	Scrap + replace RT M 81421	13-05-31 <u>\$322.09</u>	13-06-03	DAS 052022 3/06/03
Equip/Tooling									
Handling/Pre Material									
Operator	X								
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
Crushing	Countersink	Misaligned/off center	Positioned Wrong	
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other
Inspection Strip in Tube	Drawing	Misread		
Marks/Chatter	Drill Holes	Off-set		
Turning Sequence	Finish	Out of Calibration		
Wave/Twist in Tube	Fit/Function	Out of Sequence		

Work Order ID 102091

Thursday, May 23, 2013 3:29:44 PM

102091

Page 4

Item ID: D3179-041

Accept

Revision ID: U/R

Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013 **Start Qty:** 8.00

8

Required Date: 5/30/2013 **Req'd Qty:** 8.00

8

Reference:

N900040100

Setup Start

NS1

Stop

NS2

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hour**

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

190

QC

Quality Control

200

Identify as per dwg & Stock Location: ST221

0.00

200

Packaging

Packaging

0.00

2

2x M. 13-08-15

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Quality Control

0.00

13/8/2014

Npl 13-8-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

Picklist Print

Thursday, May 23, 2013 3:29:42 PM

Page 1

Work Order ID:	102091	Start Date:	5/30/2013	Required Date:	5/30/2013
Parent Item:	D3179-041	Start Qty:	8.00	Required Qty:	8.00
Parent Item Name:	Fwd Litter Tie Down				
Comments:	IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM IPP Rev:C 08-12-10 add part list DD verified by:JLM				

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149D0332J Washer		Purchased	No			100	Each	798.0000	3	24	FF	13-08-15	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST293			360						
				125268			360						
				ST294			438						
				122973			68						
				125044			370						
D2372 Quick Release		Manufactured	No			180	Each	31.0000	2	16	FF	13-08-15	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			31						
				102247									
				101076			12						
				86001			2						
				97848			5						
				99810			12						
D2444 Pip Pin Assembly		Manufactured	No			180	Each	25.0000	1	8	FF	13-08-15	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST010			25						
				101027			10						
				97238			1						
				98455			5						
				99370			4						
				99784			5						

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design <input type="checkbox"/>											
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Handling/Pre <input type="checkbox"/>											
Material <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Offset/Setup <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Transport <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear				General							
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube				Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function <input type="checkbox"/>							
				Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/>					

Picklist Print

Thursday, May 23, 2013 3:29:43 PM

Page 2

Work Order ID: 102091

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013

Required Date: 5/30/2013

Start Qty: 8.00

Required Qty: 8.00

D6201

Manufactured

No

180

f

47.9646

1.0125

8.5263158

"T" Extrusion

PD 13/05/29

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	47.96463153	
81421	4.61863153	X 4.05
83987	20	
89645	3.346	3. i
96808	20	1. i

MS210421.3

Purchased

No

180

Each

3,403.0000

1

8

Nut

END OF BATCH
FF 13-08-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	3	
122141	3	
GA	18	
122452	18	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	3114	
123900	954	
124291	2160	

MS27039-1-13

Purchased

No

180

Each

944.0000

1

8

Screw

FF F 13-08-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	2	
119736	2	
ST304	42	
119736	42	8 2
ST306	400	
125654	400	
ST506	500	
124326	500	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

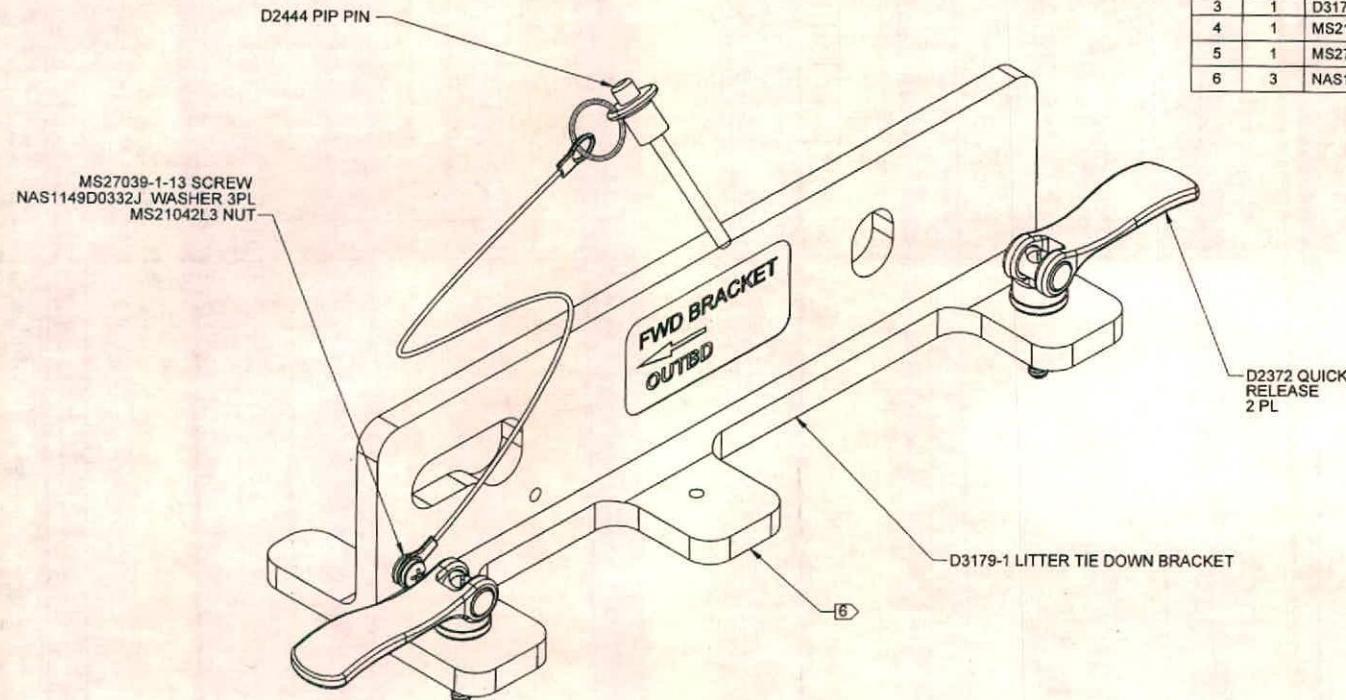
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>		
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>		
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>		
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>		
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>	Other <input type="checkbox"/>		
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>			
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>			
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>			

ITEM	QTY -041	P/N	DESCRIPTION
X	D3179-041	LITTER TIE DOWN BRACKET	
1	2	D2372	QUICK RELEASE
2	1	D2444	PIP PIN
3	1	D3179-1	LITTER TIE DOWN BRACKET
4	1	MS21042L3	NUT
5	1	MS27039-1-13	SCREW
6	3	NAS1149D0332J	WASHER (AN960JD10L)

#102091



D3179-041 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3179-041" ON BOTTOM FACE USING FINE POINT PERMANENT INK MARKER AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.79 lbs

D	POSITION AND SHAPE OF LITTER CAPTURE SLOTS CHANGED (ZN B4-2, B8-2, C7-2). ADD ENGRAVING NOTE (ZN C4-2), REF CR13-15	DB	13.03.22
C	ADD D3179-041 & PARTS LIST (ZN B8-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N	RF	08.11.07
B	REFORMAT DRAWING, FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO. D3179 REV. D	
MFG. APPR.	SJ	SHEET 1 OF 2	
APPROVED	MO	TITLE LITTER TIE DOWN BRACKET SCALE NTS	
DE APPR.	H	DATE 13.03.22	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

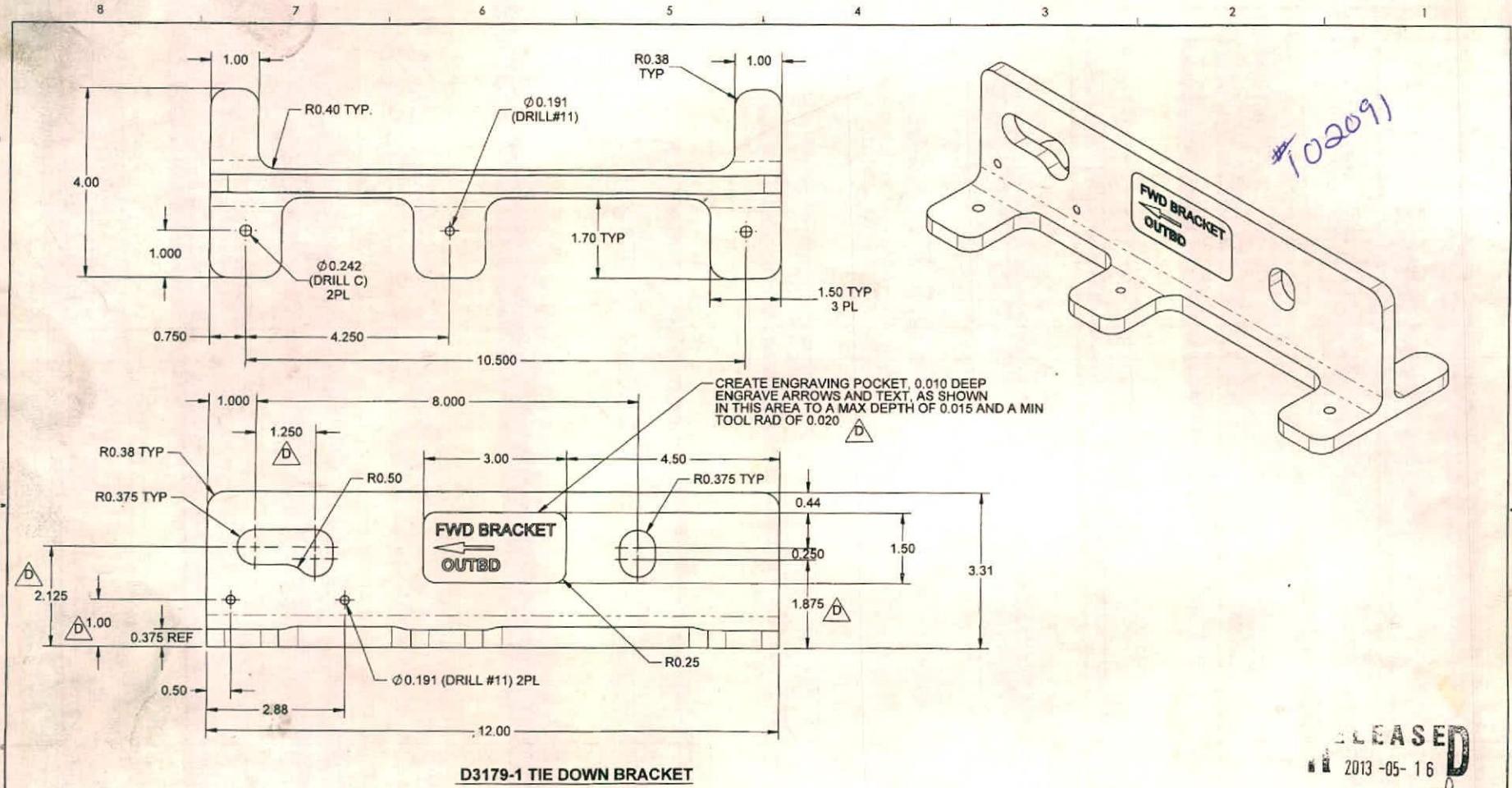
Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Outside Dimensions	Pressure/Forced
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Other <input type="checkbox"/>	
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>		
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>		
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>		
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>		



D3179-1 TIE DOWN BRACKET

RELEASED
2013-05-16
AM

NOTES:

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.35.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.90 lbs

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	SJ	D3179	SHEET 2 OF 2
APPROVED	WJ	TITLE	
DE APPR.		LITTER TIE DOWN BRACKET	
DATE	13.03.22	NTS	

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DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>		
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>		Quality <input type="checkbox"/>		
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>		
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

DART AEROSPACE LTD	Work Order:	102091
Description: Fwd litter tie down	Part Number:	3179-1
Inspection Dwg: D3179 Rev: D		Page 1 of 12

FIRST ARTICLE INSPECTION CHECKLIST

Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/- .030	1.001	✓		vern	IT-4
.191	+ .005 / - .001	.193	✓			
1.00	+/- .030	.997	✓			
1.50	+/- .030	1.499	✓			
1.70	+/- .030	1.699	✓		depth gauge	RT-6
10.500	+/- .010	10.500	✓		tape	RT-10
4.250	+/- .010	4.250	✓			
.750	+/- .010	.749	✓			
1.000	+/- .010	1.000	✓			
4.000	+/- .030	3.998	✓			
1.000	+/- .010	.999	✓			
8.000	+/- .010	8.000	✓			
3.00	+/- .030	2.990	✓			
→ 4.50	+/- .030	4.52	✓			
R.375		.3725	✓			
.44	+/- .030	.456	✓			
1.90	+/- .030	1.470	✓			
.250	+/- .010	.244	✓			
3.31	+/- .030	3.315	✓			
1.875	+/- .010	1.868	✓			-
12.00	+/- .030	12.000	✓			
Φ.242	+ .005 / - .001	.244	✓			
2.88	+/- .070	2.873	✓			

Measured by:	DAS IT 02	Audited by:	04 S-83	Preliminary Approval:	
Date:	13-09-31	Date:	13.10.3	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

+72
.2187

10.04.15



DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	22
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>JAG</i> <i>ZT 02</i>	Audited by:		Preliminary Approval:	
Date:	<i>13-09-31</i>	Date:		Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

